

Work Order ID ~~77152~~

77152

Page 1

November 28, 2011 7:33:02 AM

Item ID: D2807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door prop
 Start Date: 11/28/11 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/01/11 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: CX Date: 11/11/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2807	Rev E								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 15519 Order as per Dwg D2807Possible
 supplier:Lift Support Technologies,Saskatoon,CanadaP/N 6/15-164/50-115N
 Material release note is required

CX 11/11/28 (20)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

11/12/01 (20)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

11.11.30 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77152

November 28, 2011 7:33:02 AM

N900040100


Stop ***NS2***

20

20

Reference:

Stop *NR2*

130		0.00	
130	Small Fab		
Small Fab	Memo	0.00	
Small Fab	1-install D3671-1 as per dwg D2807		

QC	QC5- Inspect part completeness to step on W/O	0.00	<i>countes</i>
140		0.00	<i>Suzuki/ro</i>
QC	Memo		<i>(120)</i>
Quality Control			

150	Identify as per dwg & Stock Location: <u>22</u>	0.00	<u>11/02/22</u> <u>SL</u> <u>200</u>
150			
Packaging	Memo	0.00	
Packaging			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77152

November 28, 2011 7:33:02 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

20

20

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
------------	------------	---------------	-------------

0.00

160

QC

Memo

0.00

Quality Control

Number Stamp
11/12/22 [Signature]
MF 11-12-26

Picklist Print

November 28, 2011 7:33:01 AM

Page 1

Work Order ID: 77152

Parent Item: D2807-041

Parent Item Name: Door prop



Start Date: 11/28/11

Required Date: 12/01/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D3671-1 Placard		Manufactured	No			110	Each	11.0000	1	20		11/12/20	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		11							
				74171		11							
 6/15-164/50-115N Gas Spring		Purchased	No			130	Each	0.0000	1	20		11/12/11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

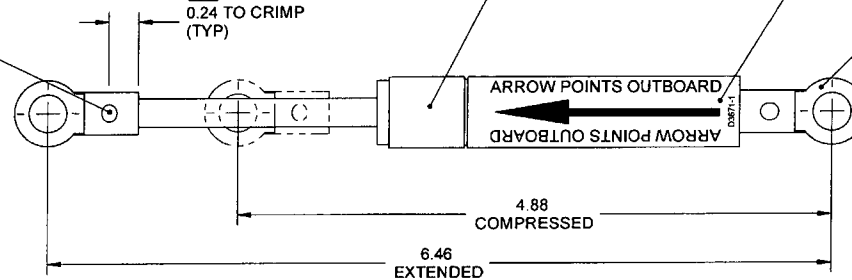
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

RELEASED
05-12-11

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

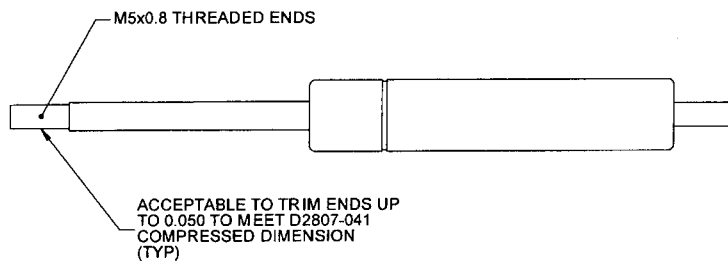
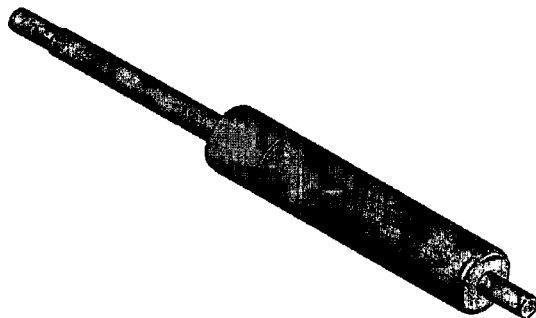
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

02/11/28
W10: 77152

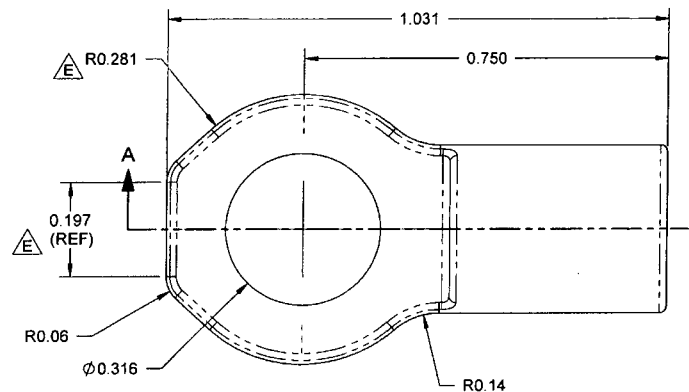
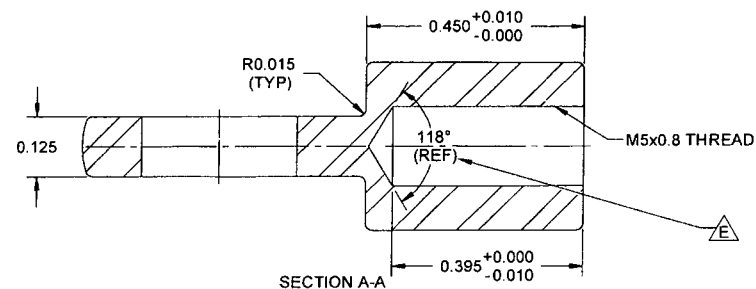
E	ADD D2807-5 GAS SPRING; D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2807 REV. E SHEET 1 OF 3 TITLE GAS SPRING SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PH		
CHECKED	KE		
MFG. APPR.	W.D.		
APPROVED	W.D.		
DE APPR.	W.D.		
DATE	07.12.28		



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

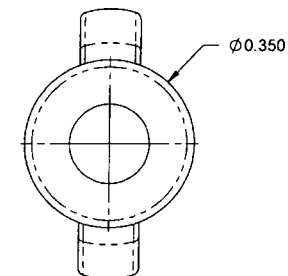
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



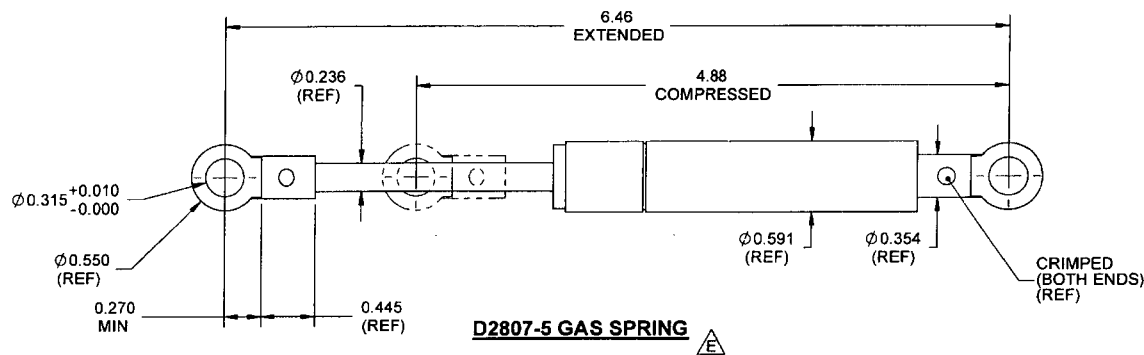
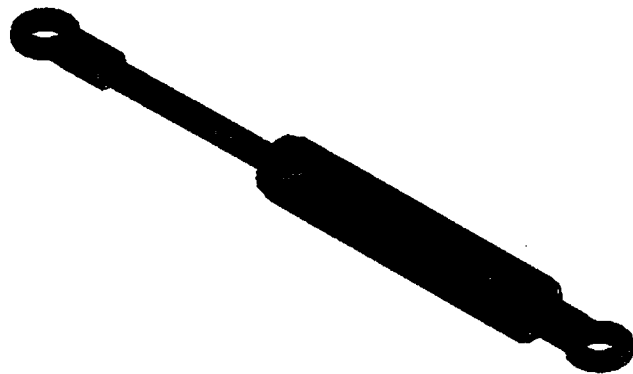
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.169 LBS

8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,

ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2807	SHEET 3 OF 3
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15549

Purchase Order Date 11/28/11

PO Print Date 11/28/11

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name

Vendor Phone

306 683 5000

Vendor Fax

306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	12/01/11 Yes	20.00 Each	FedEx PI collect	\$63.9000	\$1,278.00

Special Inst: AS PER DWG D2807 REV. E
B77152

PO Total:

\$1,278.00

Change Nbr: 1

Change Date: 11/28/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
29/11/2011	7978

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
PO15549	28/11/2011	Fed-Ex		

Qty	Description
20	D2807 Stainless Gas Spring (6/15-164/50-115N) Shipping Via FED EX Tracking # 797781781578



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

November 29, 2011

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

Date of Manufacture : November, 2011

This product is ROHS compliant.

Purchase Order # 15549

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "N Fehr", written over a horizontal line.

Nolan Fehr
President